

Work Order ID 50252

July 14, 2009 10:42:45 AM

Page 1

Item ID: D3404-1

Accept

Revision ID: C

Item Name: GHW Lug

Setup Start

Stop

Start Date: 7/15/09 Start Qty: 22.00

Required Date: 7/15/09 Req'd Qty: 22.00

Cust Item ID:

Customer:

Reference:

09-07-16

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3404

Rev C

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.750" long

09/08/17

22

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 Dwg Rev: C Folio Rev:

AA 112-Deburr

09/08/19

09/08/20

22

PRO

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

09/08/19

09/08/20

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3404-1 PAR #: N/A Fault Category: Machine NCR: (Yes) No DQA: W Date: 09.08.26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: W Date: 09.08.27

NCR: 50252		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/08/19	110	One part lift off the vise on the first operation when roughing the part. R.C. Program error feed Too fast in prog.	<u>BS1042</u>	Scrap, replace M <u>110770</u> Qty 1 Feed was reduced in speed.	<u>W</u> 09/08/19	<u>W</u> 09/08/19	<u>BS1042</u>	<u>09.08.19</u>
			<u>BS1042</u>				<u>BS1042</u>	<u>09.08.19</u>

NOTE: Date & initial all entries

Work Order ID 50252

July 14, 2009 10:42:45 AM



Page 2

Item ID: D3404-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: GHW Lug

Start Date: 7/15/09 Start Qty: 22.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 22.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

mf 09/08/20

22 0



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: *W/A*

0.00



Packaging

Memo

*Larock
Broth*

0.00

EL

9-8-20

(K22)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/08/25

Quality Control

mf 09-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 10:42:44 AM

Page 1

Work Order ID: 50252

Parent Item: D3404-1RevC

Parent Item Name: GHW Lug


Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 22.00

Required Qty: 22.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	28.8000	5.3055			
												
304 BAR .750 X 2.50												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

110777

28.8

28.8

5.3055 - m 09/08/17

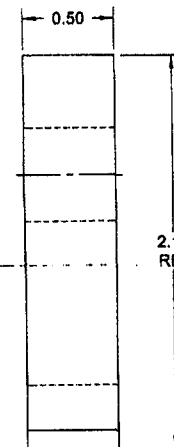
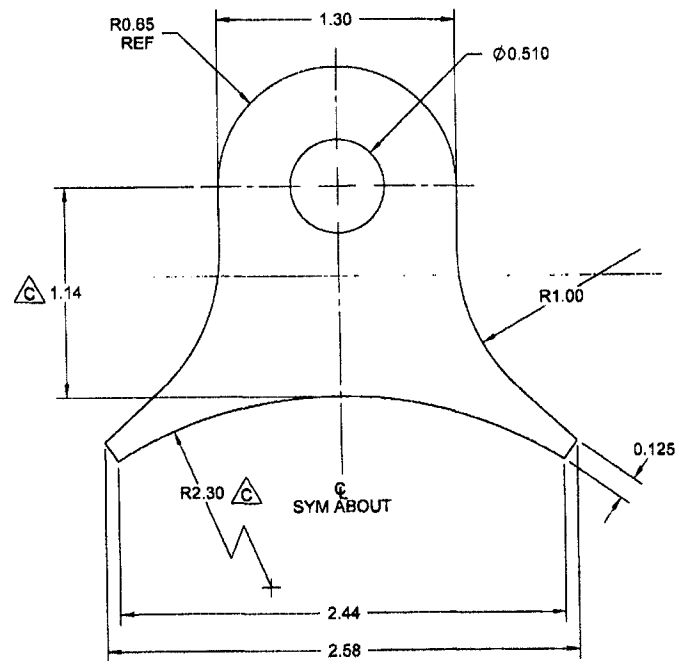
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



50252

RELEASED
08/12/15 VML

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	




D3404-1 GHW LUG

50252

RELEASED
08/12/02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3404	REV. C
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
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